

Date: Monday, 5/15/2006 11:10:36 AM  
 User: Kim Johnston

## Process Sheet

*Split*  
*JB 06/06/13*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY  
 Job Number : 27102-2  
 Estimate Number : 11036  
 P.O. Number : NIA Part Number : D2804041  
 This Issue : 5/15/2006 S.O. No. : NIA Drawing Number : D2804 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 5/15/2006 Type : R & D SM/MED FAB Drawing Revision : B  
 Previous Run : 25919 Material : NIA  
 Due Date : 6/5/2006 Qty: 20 Um: Each  
 Written By : *SKJ COMMENT BELOW*  
 Checked & Approved By : *06.05.15 W*  
 Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28041 STA 155 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 STA 155 Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2804-1	Bracket	<i>B27112</i>

2.0 D28051 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 Stop

Pick:

Qty	Part Number	Description	Batch
1	D2805-1	Stop	<i>B27304 4</i> <i>B25931 16 M.F. 06/06/08</i>

D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	<i>B27306 x 13</i> <i>B25959 x 17</i> <i>FF 06.06.14</i>

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Press D2805-1 into arm as per Dwg D2804

*m.f. 06/06/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 5/15/2006 11:10:36 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27102

Part Number: D2804041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/06/07 20

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/12 20

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 06:06:13 20

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2804

FF 06.06.13 PTO 18

9.0 AN3C16A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt  
Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M19944 x36
			M10164 x4

FF 06.06.13 18

10.0 MS210433 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut  
Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	M100210

FF 06.06.13 18

11.0 NAS1515H3 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Washer  
Pick:

Qty	Part Number	Description	Batch
			4 NAS1515H3

Washer - M19633 18




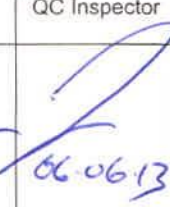
A/R LPS-3 Corrosion Spray

M17045

FF 06.06.13



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.06.13	8	1J02809 over pressed		Taken out of bracket and Destroyed	06.06.13 FF	 06.06.13		 06.06.13

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/13

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 5/15/2006 11:10:36 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27102

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

FF

06.06.14

18

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.06.14

18

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST158

AR 06.06.14 (18)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06.06.14

(18)

Job Completion



U 06.06.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

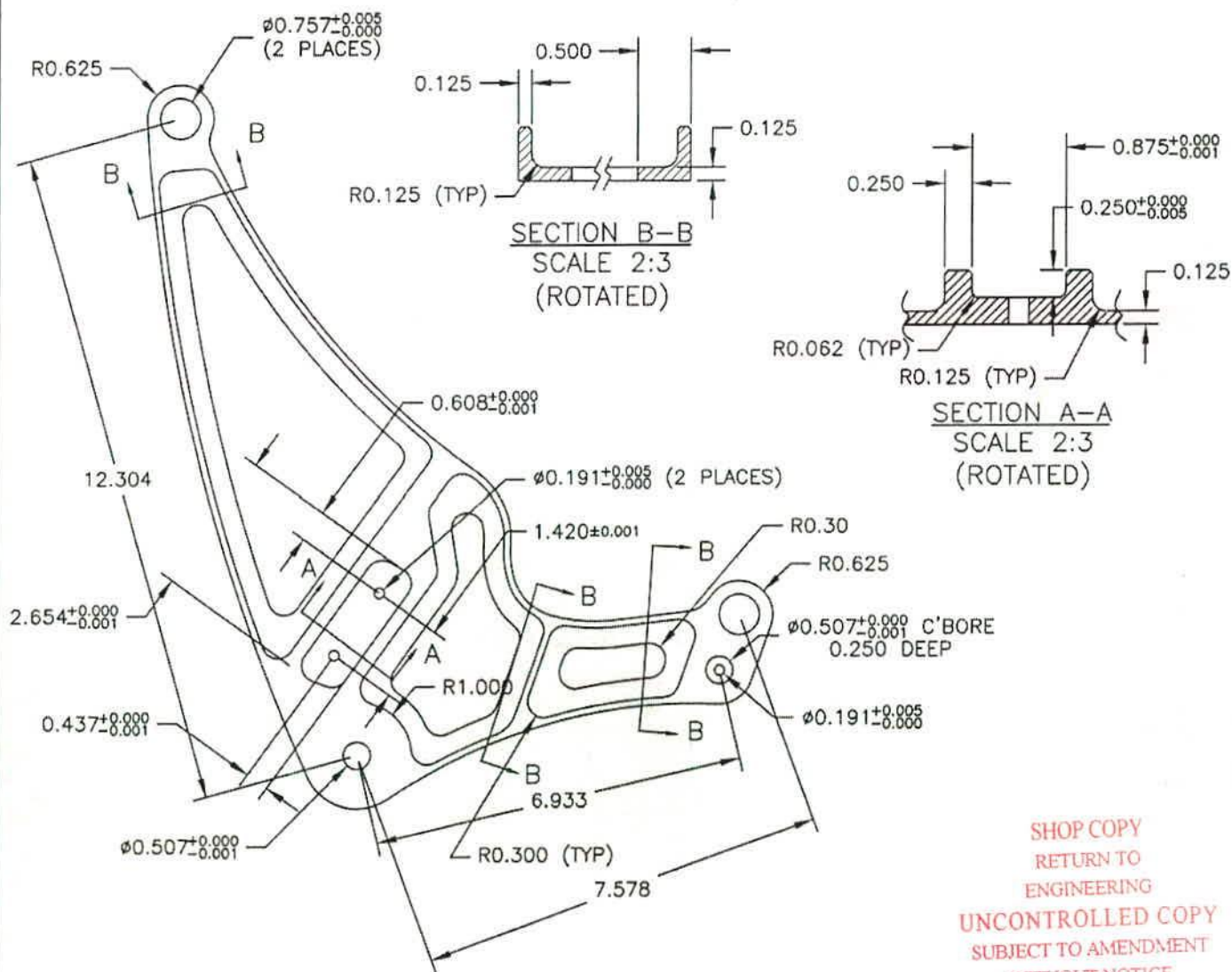


**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2804	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 155 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05.03.11



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WORK ORDER  
NO. 27102

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

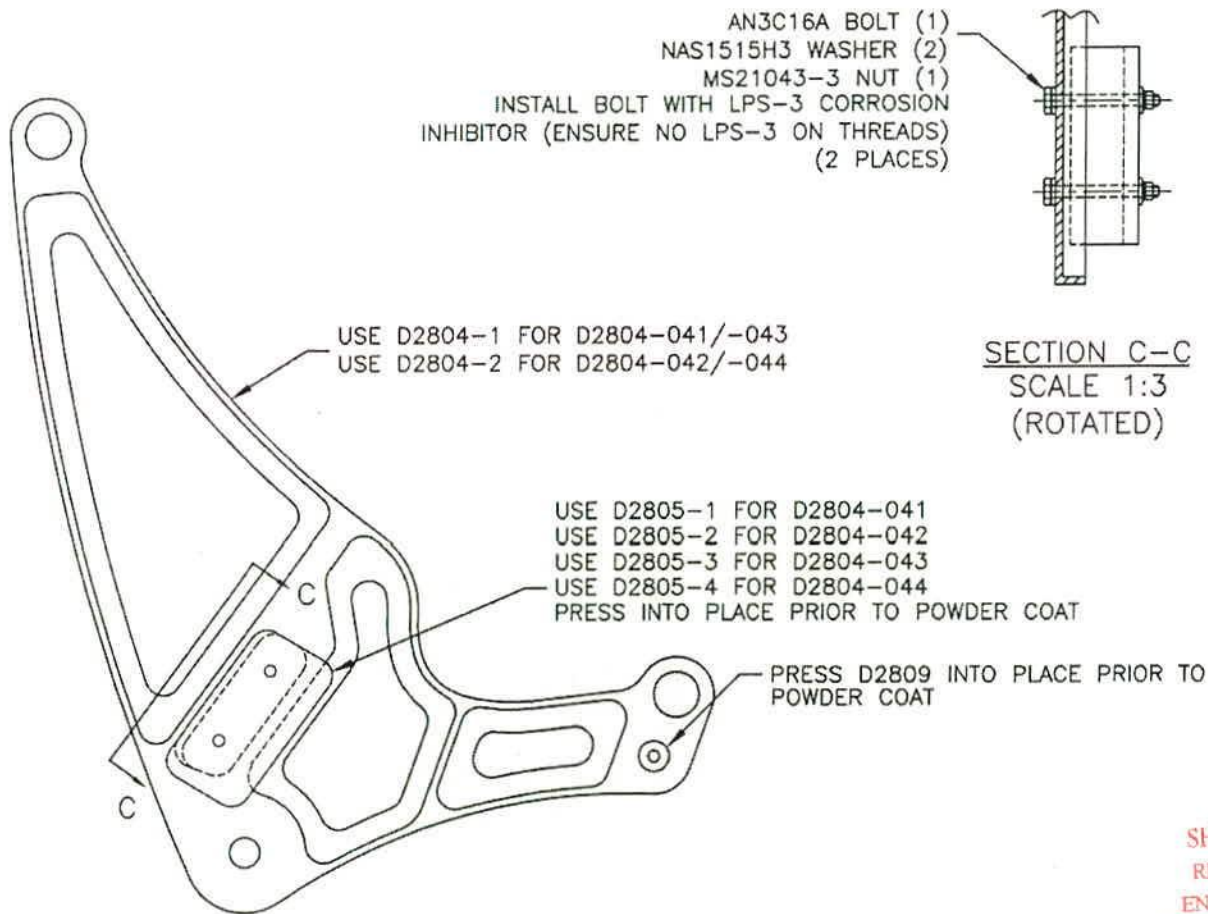
- 1) MACHINE PER DRAWING FILE "D2804.SLDprt"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804
				REV. B SHEET 2 OF 2
DATE	04.11.22	TITLE	STA 155 BRACKET	SCALE 1:3



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05-03-11 *[Signature]*  
WORK ORDER  
NQ 27102

D2804-041/-043 BRACKET ASS'Y (SHOWN)  
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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